

Advanced Materials**Araldite® 2015-1****Structural Adhesives****TECHNICAL DATASHEET**

Araldite® 2015-1

Two component epoxy paste adhesive

Key properties

- Toughened paste
- Ideal for bonding GRP, SMC and dissimilar substrates
- Gap filling, non-sagging up to 10mm thickness
- Good resistance to weathering

Description

Araldite® 2015-1 is a two component, room temperature curing paste adhesive giving a resilient bond. It is thixotropic and non-sagging up to 10mm thickness. It is particularly suitable for SMC and GRP bonding.

Product data

Property	Araldite® 2015-1 Resin	Araldite® 2015-1 Hardener	Mixed Adhesive
Colour - visual (A112)*	beige paste	beige paste	beige paste
Specific gravity	1.4	1.4	1.4
Viscosity at 25 °C (Pa.s)	thixotropic	thixotropic	thixotropic
Lap shear strength at 25 °C (A501)*	-	-	> 15 MPa
Pot Life (100 g at 25°C)	-	-	45 - 55 minutes

* Specified data are on a regular basis analysed. Data which is described in this document as 'typical' is not analysed on a regular basis and is given for information purposes only. Data values are not guaranteed or warranted unless if specifically mentioned.

Processing**Pretreatment**

The strength and durability of a bonded joint are dependent on proper treatment of the surfaces to be bonded.

At the very least, joint surfaces should be cleaned with a good degreasing agent such as acetone, iso-propanol (for plastics) or other proprietary degreasing agents in order to remove all traces of oil, grease and dirt.

Low grade alcohol, gasoline (petrol) or paint thinners should never be used.

The strongest and most durable joints are obtained by either mechanically abrading or chemically etching ("pickling") the degreased surfaces. Abrading should be followed by a second degreasing treatment.

Mix ratio	Parts by weight	Parts by volume
Araldite® 2015-1 Resin	100	100
Araldite® 2015-1 Hardener	100	100

Araldite® 2015-1 is available in cartridges incorporating mixers and can be applied as ready to use adhesive with the aid of the tool recommended by Huntsman Advanced Materials.

Application of adhesive

The resin/hardener mix may be applied manually or robotically to the pretreated and dry joint surfaces. Huntsman's technical support group can assist the user in the selection of a suitable application method as well as suggest a variety of reputable companies that manufacture and service adhesive dispensing equipment.

A layer of adhesive 0.05 to 0.10 mm thick will normally impart the greatest lap shear strength to the joint. Huntsman stresses that proper adhesive joint design is also critical for a durable bond. The joint components should be assembled and secured in a fixed position as soon as the adhesive has been applied.

For more detailed explanations regarding surface preparation and pretreatment, adhesive joint design, and the dual syringe dispensing system, visit www.aralditeadhesives.com.

Equipment maintenance

All tools should be cleaned with hot water and soap before adhesives residues have had time to cure. The removal of cured residues is a difficult and time-consuming operation.

If solvents such as acetone are used for cleaning, operatives should take the appropriate precautions and, in addition, avoid skin and eye contact.

Typical times to minimum shear strength

Temperature	°C	10	15	23	40	60	100
Cure time to reach	hours	10	6	4	1	-	-
LSS > 1MPa	minutes	-	-	-	-	20	3
Cure time to reach	hours	20	15	8	3	-	-
LSS > 10MPa	minutes	-	-	-	-	40	5

LSS = Lap shear strength.

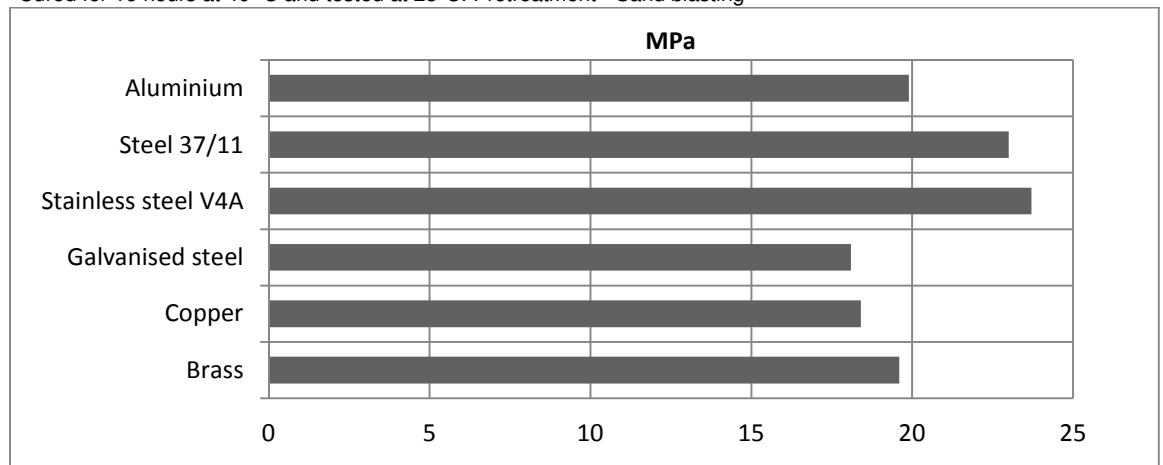
Typical cured properties

The figures were determined with typical production batches using standard testing methods. They are provided solely as technical information and do not constitute a product specification.

Unless otherwise stated, the figures given below were all determined by testing standard specimens made by lap-jointing 114 x 25 x 1.6 mm strips of aluminium alloy. The joint area was 12.5 x 25 mm in each case.

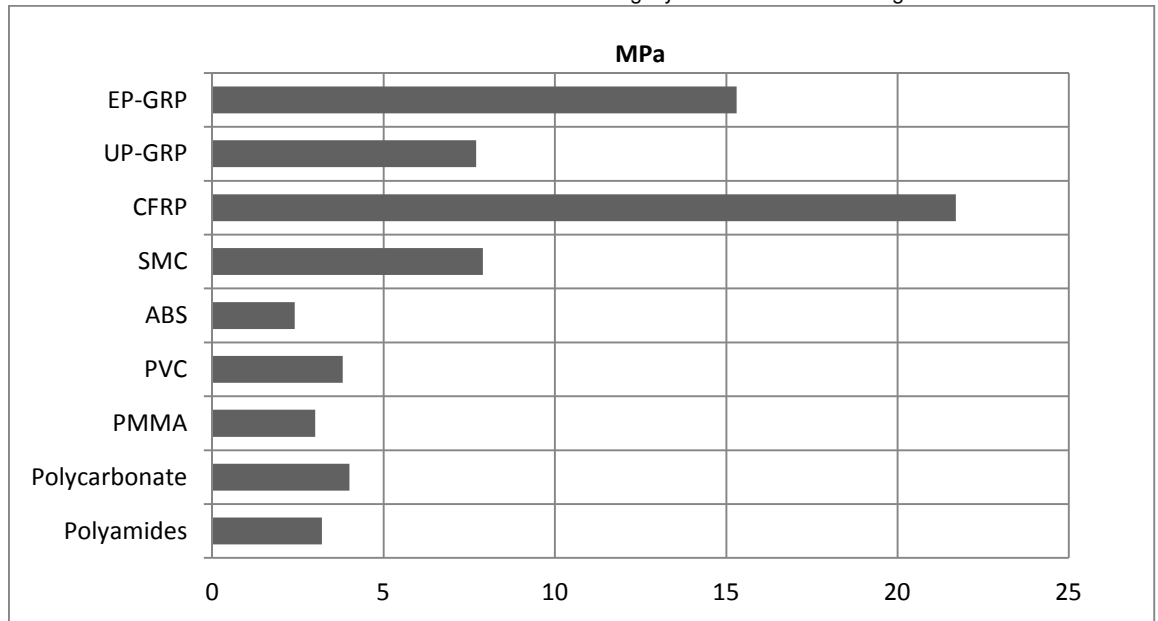
Average lap shear strengths of typical metal-to-metal joints (ISO 4587) (typical average values)

Cured for 16 hours at 40°C and tested at 23°C. Pretreatment - Sand blasting



Average lap shear strengths of typical plastic-to-plastic joints (ISO 4587) (typical average values)

Cured for 16 hours at 40°C and tested at 23°C. Pretreatment – Lightly abrade and alcohol degrease

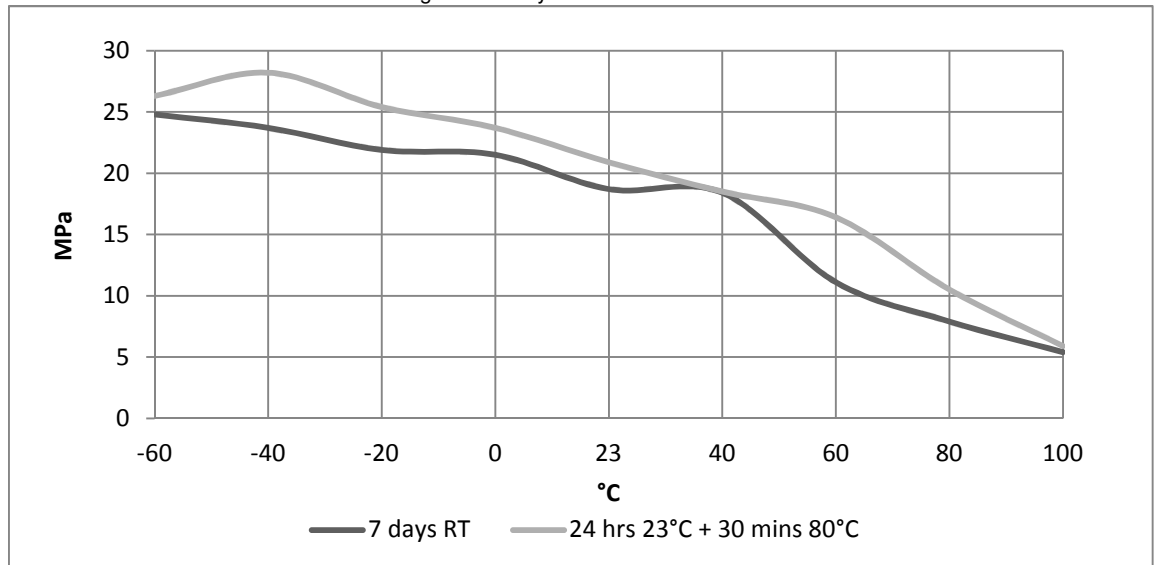


Tensile properties (ISO 527) (typical average values) Cure 16 hours at 40 °C - tested at 23 °C

Tensile strength	31 MPa
Tensile modulus	1600 MPa
Elongation at break	4.2 %

Lap shear strength versus temperature (ISO 4587) (typical average values)

On aluminium. Pretreatment - Sand blasting. Cure 7 days at RT or 24 hours at 23 °C + 30 min at 80 °C



Glass transition temperature (typical average value)

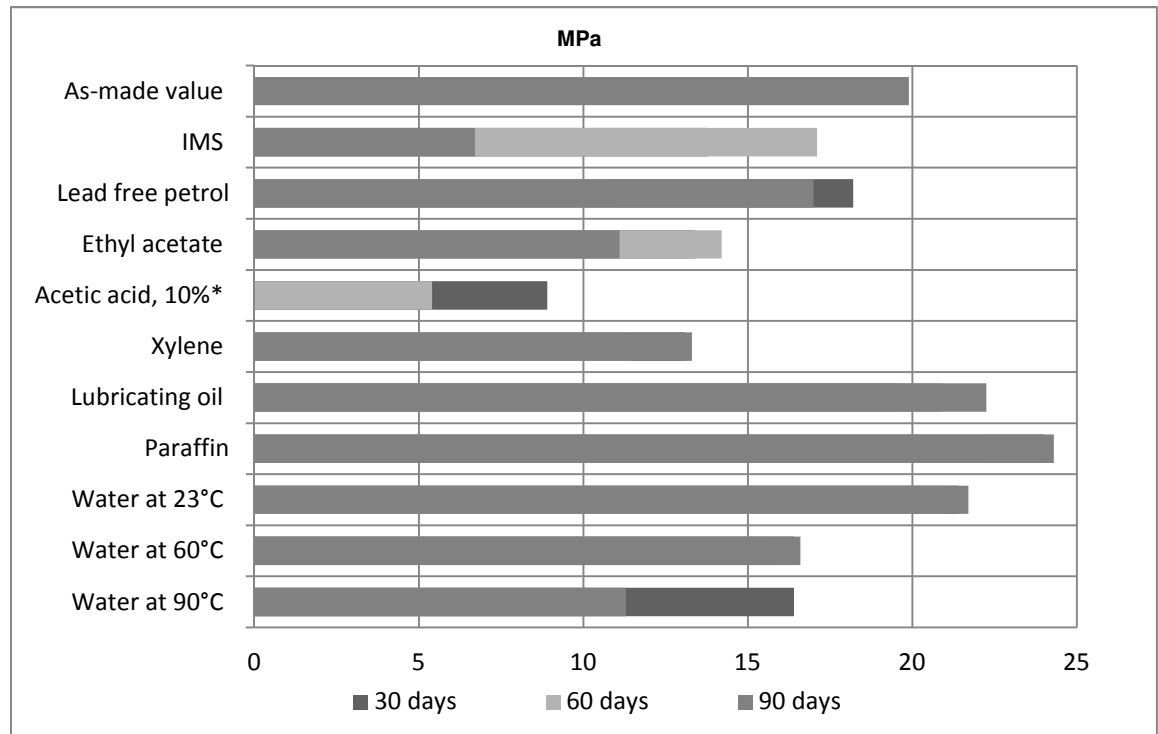
Cure: 1 hour at 80 °C

78 °C by DMA

Lap shear strength versus immersion in various media (typical average values)

On aluminium, cured for 16 hours at 40 °C and tested at 23 °C. Pretreatment - Sand blasting

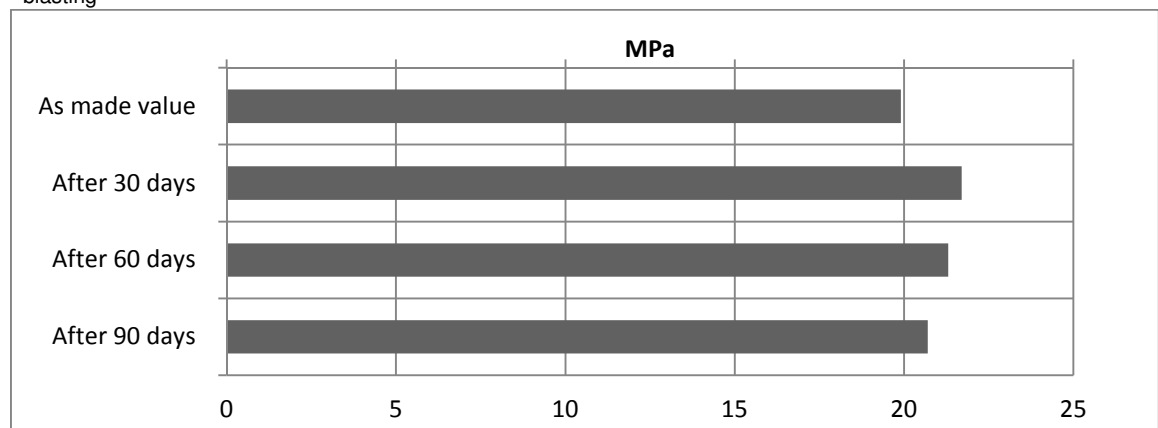
Unless otherwise stated, L.S.S. was determined after immersion for 30, 60 and 90 days at 23 °C



*: degraded in acetic acid after 90 days

Lap shear strength versus tropical weathering (typical average values)

(40 °C/92% Relative Humidity) On aluminium, cured for 16 hours at 40 °C and tested at 23 °C. Pretreatment - Sand blasting



DMA Shear modulus G' (ISO 6721) (typical average values).

Cure: 1 hour at 80 °C

Temperature	G'
-50 °C	1.8 GPa
0 °C	1 GPa
20 °C	900 MPa
50 °C	540 MPa
75 °C	61 MPa
100 °C	12 MPa

Flexural Properties (ISO 178) (typical average values).

Cure 16 hours at 40 °C , tested at 23 °C

Flexural Strength

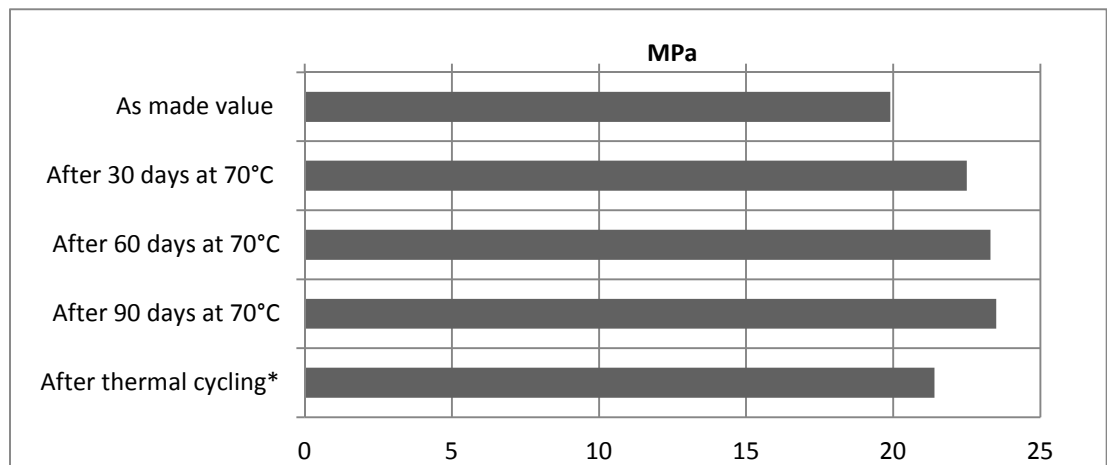
43 MPa

Flexural Modulus

1800 MPa

Lap shear strength versus heat aging (typical average values)

On aluminium, cured for 16 hours at 40 °C and tested at 23 °C. Pretreatment - Sand blasting



* Thermal cycling: 25 cycles of 6 hours duration from -30 °C to 70 °C

Storage

Araldite® 2015-1 must be stored at room temperature provided the components are stored in sealed containers. The expiry date is indicated on the label.

Handling precautions**Caution**

Our products are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the Material Safety Data sheets for the individual products and should be referred to for fuller information.

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